

Split.

Work Order ID 57234 - 2

March 30, 2010 6:16:48 PM

Page 1

Item ID: D4082-1

Revision ID:

Item Name: Mounting Bracket

Start Date: 30/03/2010 Start Qty: 4.00

Required Date: 31/03/2010 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Cust Item ID:

Customer:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4082

A

100

0.00

Waterjet

FLOW CNC Waterjet

Memo

Cut Blank as per file D4082-1_BLANK

DO NOT PASS IN DEBURRING MACHINE

0.00

110

0.00

HAAS I

HAAS I

HAAS CNC vertical machine #1

Memo

MILL AS PER DWG AND FOLIO FA919

FOLIO REV: AA

DWG REV: AA

DEBURR

SL AA 10.4.4 ① ①

110

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4082-1 PAR #: _____ Fault Category: prod eng covered -NCR: Yes No DQA: / Date: 10.04.12
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: _____

NCR: <u>57234-2</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.01.02	110	PART SCRAPED DUE TO RE-GEN PROC AND FORGOT, TO INSERT MOO, THEREFORE PROC DID NOT STOP.	<u>[Signature]</u> 10/04/12	INSERT MOO	<u>[Signature]</u> 10.04.12	<u>[Signature]</u> 10.04.12	<u>[Signature]</u> 10/04/12	<u>[Signature]</u> 10/04/12

NOTE: Date & initial all entries

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Item ID: D4082-1

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Start Date: 30/03/2010 Start Qty: 4.00

Required Date: 31/03/2010 Req'd Qty: 4.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

131



Small Fab

Small Fab

Drill as per Day
using DT8560
Memo

0.00

0.00

7 m.h 10/04/06 (IX)

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Item ID: D4082-1

Accept

Revision ID:

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Start Date: 30/03/2010 Start Qty: 4.00

Required Date: 31/03/2010 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

132

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8.10/04/06

(X1)

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

=> 10/04/07

(X1)

φ

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

M113170 START: 7:00am
Temp: 320°C
Fin: 7:30am

=> 10/04/07

(X1)

φ

Work Order ID 57234

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Item ID: D4082-1

Accept



Setup Start



Revision ID:

Item Name: Mounting Bracket

Stop



Start Date: 30/03/2010 Start Qty: 4.00



Required Date: 31/03/2010 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 10-4-7

DP

170

Identify as per dwg & Stock Location: 139R

0.00



Packaging

Memo

0.00

Packaging

Packaging 10/4/8 U

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/12

W 10-04-08

Picklist Print

March 30, 2010 2:08:22 PM

Page 1

Work Order ID: 57234

Parent Item: D4082-1

Parent Item Name: Mounting Bracket

Comments: IPP REV:A NEW ISSUE 10-03-30 JLM VERIFIED BY:EC

Start Date: 30/03/2010

Required Date: 31/03/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.000X12.00 0		Purchased	No			100	f	6.6206	9.1225			



6061-T6 Bar 1.00 x 12.00



B10-3-30

15.00
10.03.30
Full Batch
This Only

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT05

6.6206

104719

2.5

106701

4.1206

B33680

33680

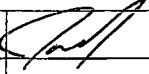
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DART AEROSPACE LTD		Work Order: 57234
Description: mounting bracket		Part Number: 14072-1
Inspection Dwg: 14072	Rev: A	Page 1 of 1

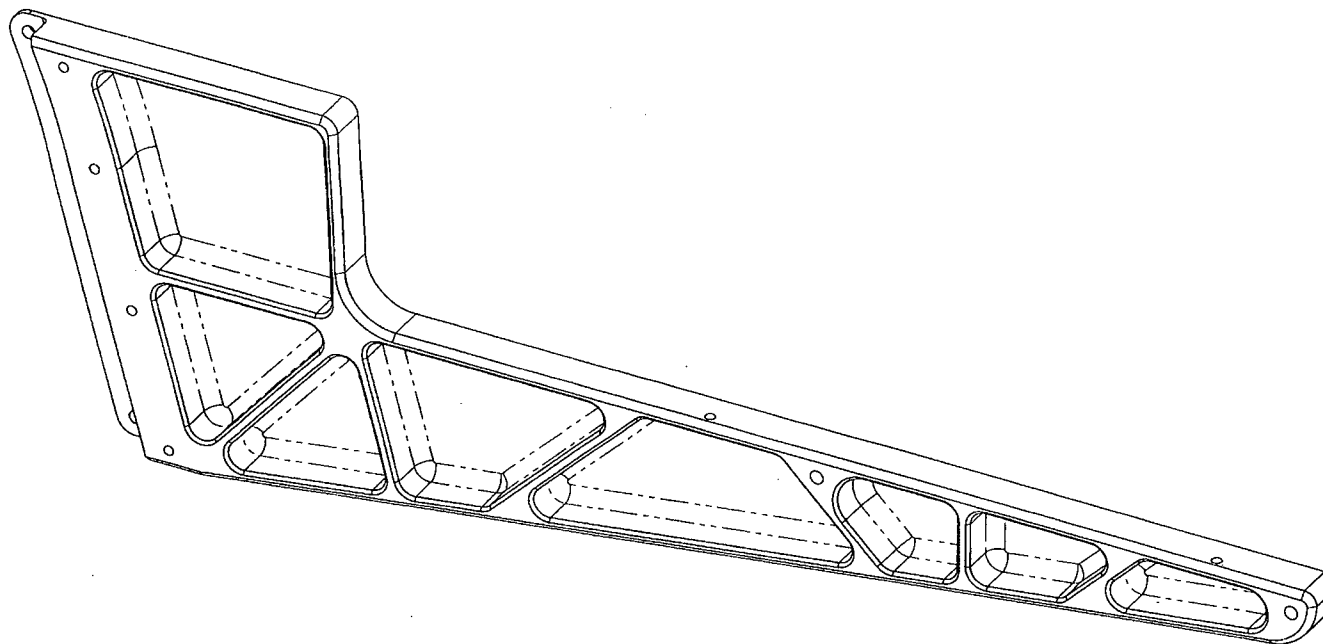
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.13	+ .030					
Ø.257	+ .006 - .001	.258	✓			
1.38	+ .030	.38	✓			
1.076	+ .010	1.076	✓			
6.72	+ .030	6.730	✓			
1.985	+ .010	1.985	✓			
.440	+ .010	.440	✓			
1.25	+ .030	.250	✓			
4.00	+ .030					
9.372	+ .010	9.372	✓			
13.848	+ .010					
Ø.191	+ .005 - .001	.191	✓			
1.035	+ .010	1.035	✓			
.500	+ .010	.501	✓			
2.776	+ .010	2.776	✓			
8.00	+ .030	8.001	✓			
7.546	+ .010	7.546	✓			
1.000	+ .010	1.001	✓			
3.290	+ .030	3.285	✓			
3.11	+ .030	3.108	✓			
.250	+ .010	.253	✓			
4.720	+ .010	4.716	✓			
6.37	+ .030	6.370	✓			

Measured by:	Audited by: 	Prototype Approval:	N/A
Date:	Date: 12-04-12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4082-1 MOUNTING BRACKET

RELEASED
R 2010-03-30
wp

57234

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET (OR PLATE)
PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR
AMS 4025 OR AMS 4027
OR ASTM B209
REF. DART SPEC. M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4082-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 3.61 lbs

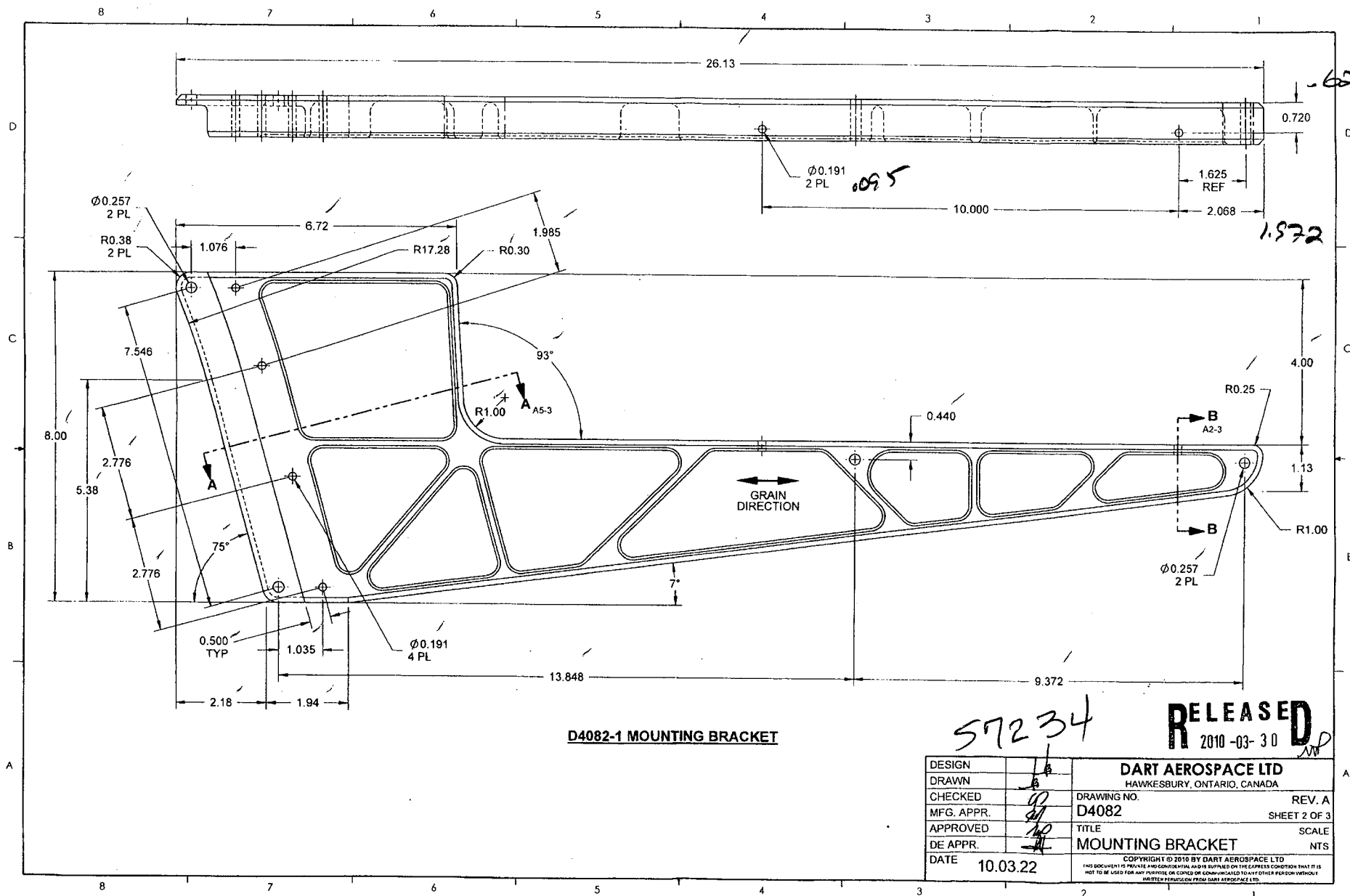
A		NEW ISSUE		DESCRIPTION		MB	10.03.22
REV.						BY	DATE
DESIGN							
DRAWN							
CHECKED							
MFG. APPR.							
APPROVED							
DE APPR.							
DATE							

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

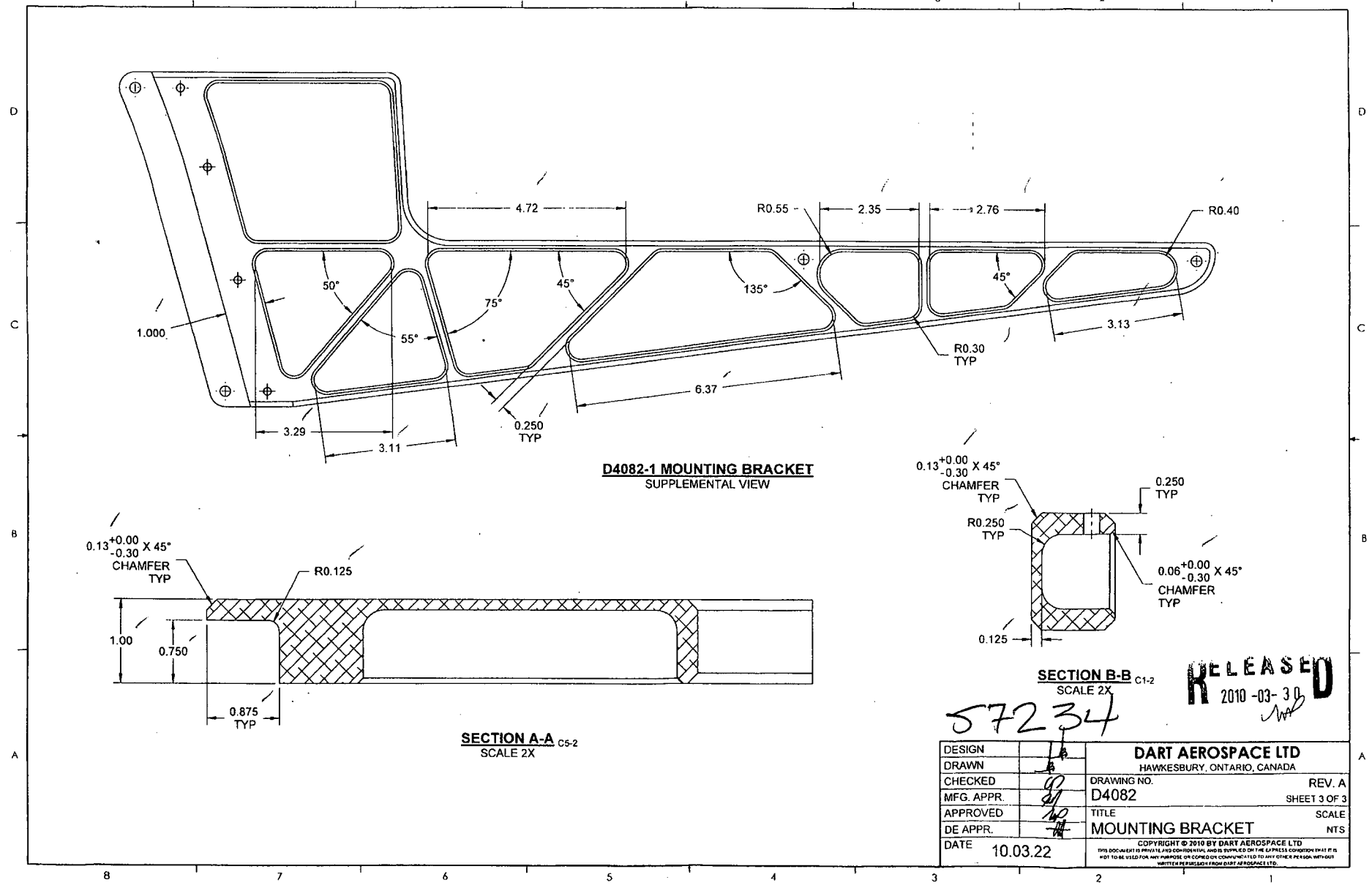
DRAWING NO. **D4082** REV. A
SHEET 1 OF 3

TITLE **MOUNTING BRACKET** SCALE NTS

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8 7 6 5 4 3 2 1



57234

RELEASED
2010-03-30

DESIGN	1	DART AEROSPACE LTD	
DRAWN	1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1	DRAWING NO.	REV. A
MFG. APPR.	1	D4082	SHEET 3 OF 3
APPROVED	1	TITLE	SCALE
DE APPR.	1	MOUNTING BRACKET	
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